

Date: Monday, 04/05/2009 1:47:13 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 47719	
Estimate Number : 12974	
P.O. Number :	Part Number : D36463 BK
This Issue : 04/05/2009 S.O. No. :	Drawing Number : D3646 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 43318	Material :
Written By :	Due Date : 10/05/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 09-05-06</u>	
Comment : Est Rev. A new issue 07.07.25 EC verified by:JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 3.0555 f(s)/Unit Total : 18.3330 f(s)
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Batch: M 111 704

FF 09-05-25

⑥

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Punch to length as per Dwg D3646 & template DT8959

FF 09-05-25

⑥

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- Bend as per dwg D3646

FF 09-05-25

⑥

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 09/05/26

⑥

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------

**Comment:** POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

JH 09-05-27X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 1:47:13 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47719

Part Number: D36463

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME: 2:15pm

OVEN TEMPERATURE: 320°

FINISH TIME: 2:45pm

94 09-05-27 X6

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FA 09/05/27 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57229

Pa 9/6/28 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/28 J

Job Completion



MF
09-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

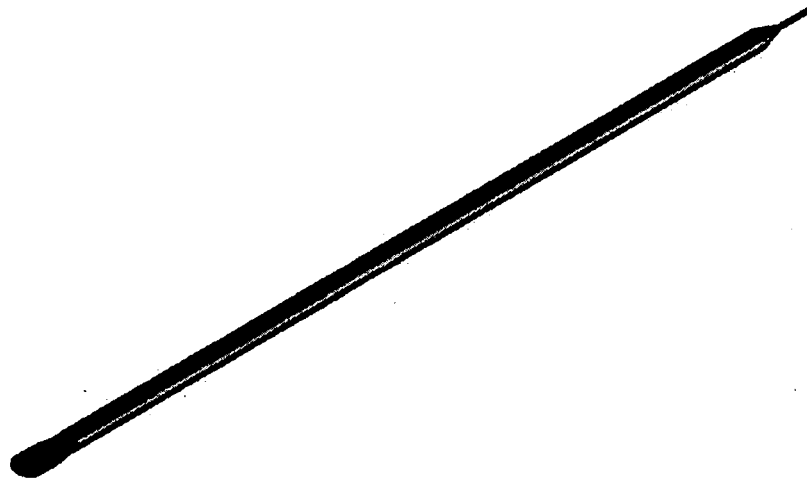
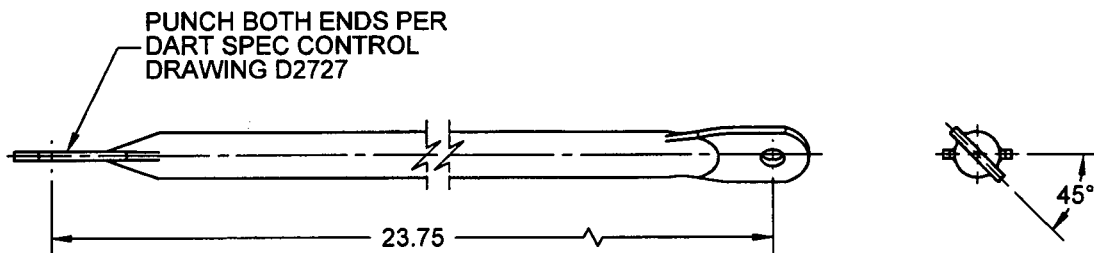
NOTE: Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3646	REV. A SHEET 1 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:2
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE	

RELEASED

07.07.11 *PH*



D3646-1 ARM

NOTES:

- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

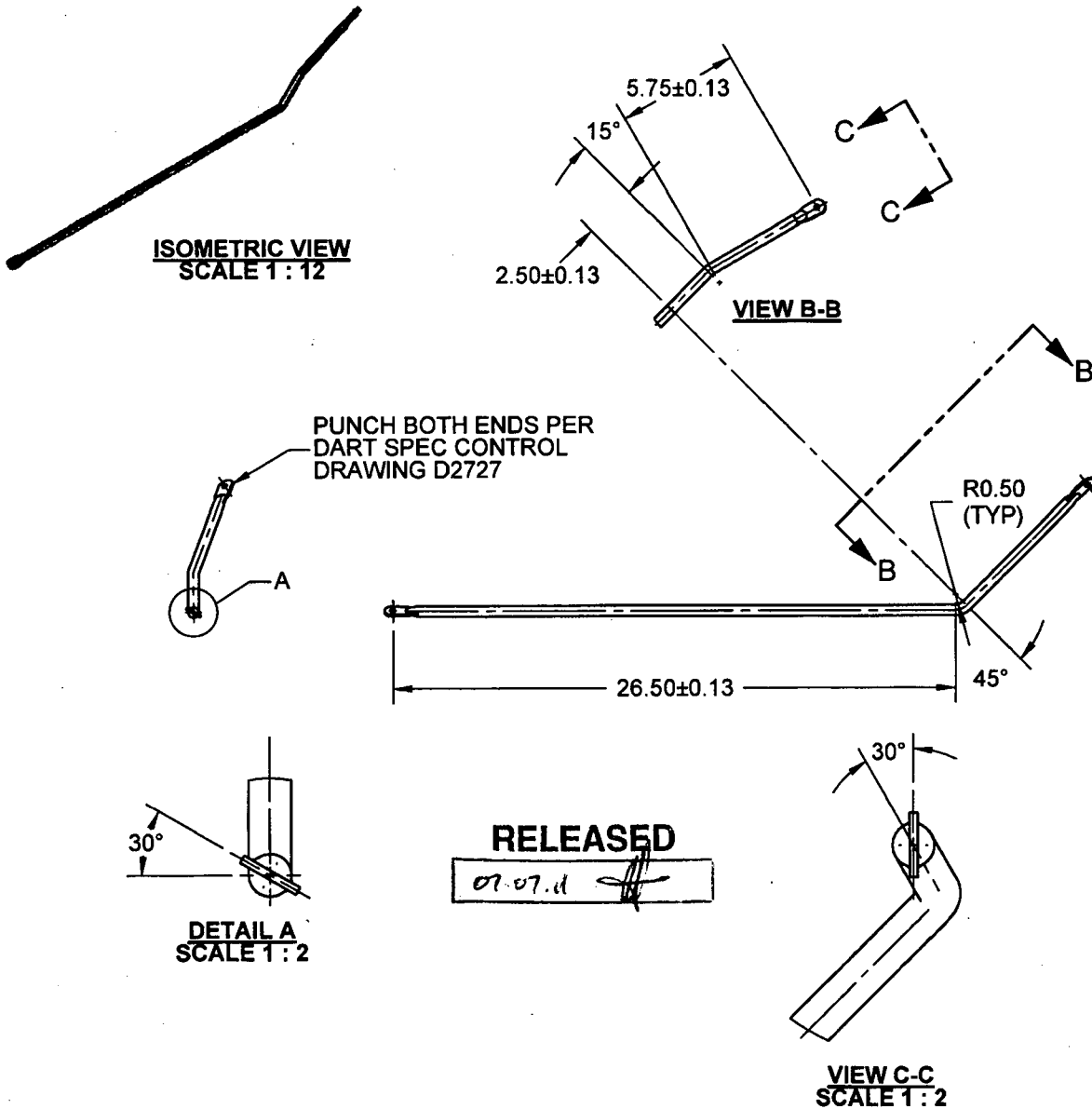
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DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3646	REV. A SHEET 2 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:8

**D3646-3 ARM****NOTES:**

- 1) MAKE PER TEMPLATE DT8959
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 TO 4.7
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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